	r ID 120245 04, 2014 2:59:47 PM		*120	1245*							Page 1	
Item ID: I Revision ID:	D3543-1		Accept	*N900	0040	100)*	Setup	Start	*N	S1*	
Item Name:	Hinge Panel Door Push-Out Windo	ow							Stop	*N	S2*	
Start Date: 6	5/04/14 Start Qty: 4.00	*4*		Cust Item	ID:							
Required Date: 6 Reference:	6/04/14 Req'd Qty: 4.00	*4*	•	Customer:								
	Process Plan: ML5	Date: 14 66-65	Tooling:	D	ate:]	Run	Start	*N	R1*	
ļ	QC:	Date:	SPC (Y/N):	D	ate:				Stop	*N	R2*	
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp	
Draw Nbr	Revision Nbr										1	-
D3543	Rev B											
100	FLOW WATER JET		0.00				6	`		æ	14/09/07	DAS 23 9-89
Waterjet	Memo	D D0540	0.00								17-7-	0-03
FLOW CNC Waterjet 18° Plexislas	Dwg Rev Prog Rev	per Dwg D3543 v: v: r if necessary										
110	QC2- Inspect parts of	ff machine FAI/FAIB	0.00								//	DAS
*11 0 *	Memo		0.00							De	14/09/07	7 23 9-89
Quality Control												
120	QC8- Inspect parts -	second check	0.00								DAS 38	// O Y
120	Memo		0.00				(6)				9-89 /4	<i>1ーアー</i> 7

Memo

Quality Control

DQA:			Date:			WORK ORDER NON	-		DAAANGE / LIDDATE				•	`DART
QA Closed:			Date:			WORK ORDER NON-		JNFOI	RIVIANCE / UPDATE	W	ork Order up	odate only		AEROSPACE
Mark Orde						DISPOSITION			AGAINS	r DE	PARTMENT	/PROCESS		
Work Orde	: · · –					Rework			Skid-tube Crosstube	<u>_</u>	7	Water Jet	٦	Engineering
Part N	lo.					Scrap			Machining Small Fall		- Pro	d. Eng. Coor.	\dashv	Quality
· Gren	-					Use-as-is			noforming Finishing	_	-1	re/Packaging	\dashv	Other
NCR N	lo					Suspected Unapproved			Large Fab Composite]	Supplier		
D - 1	<u> </u>				Dagg	::		nitial	Action		Sign &		$\overline{}$	
Root		Data	Cton	O#1.	Desci	ription of work order update or non-conformance		nitial iief Eng			Date	Verification		QC Inspector
Cause	\dashv	Date	Step	Qty		or non-comormance	Cil	ilei ciig	Description	_	Date	Vermeation	+	QC mspector
Design Doc/Data	-													-
Equip/Tooling	\dashv													
Handling/Pre	\dashv													
Material	-						ĺ							
Operator														
Offset/Setup														
Process														
Supplier	\Box		ļ											
Training							Ì							
Transport						-								
Unapproved														
							FAI	ULT CA	TEGORY					
Landi	ng G	ear				General		_			-	_	_	
.,		Bending				Bend		Folio/F	Program		Outside Dim	ensions	— 1	ressure/Forced
		Centre No	ot Concer	ntric		BOM/Route	L	Grain		_	Over/Under	tolerance	-	et-up
		Cracks				Broken/Damage/Defect		Hardwa	are	L	Part Incorre	<u> </u>	_	emperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqualified	L	Part Lost/M	issing	_	Veld
		Cuffs				Contamination	<u>_</u>	4	tions Incomplete/Unclear	L	Part Moved	L		Vrong Stock Pulled
	Ш	Crushing				Countersink		4	gned/off center		Positioned V	_	_	
	\vdash	Heat Trea			<u> </u>	Cut Too Short	\vdash	Mislabe			Power Loss/	Surge	C	Other
	${f -}$	Inspection		Tube		Drawing	_	Misrea						
٠		Marks/Ch			<u> </u>	Drill Holes	_	Off-set					-	
	-	Turning S	-			Finish	<u> </u>	4	Calibration					-
		Wave/Tw	<u>ist in Tub</u>	oe		Fit/Function		Out of	Sequence					

Work Orde Wednesday, June				*120)245*							Page 2	2
Item ID: Revision ID: Item Name:	D3543-1 Hinge Panel I	Door Push-Out Window		Accept	*N900	040	100	ገ*	Setup	Start Stop	171	S1* S2*	
Start Date: Required Date: Reference:	6/04/14 6/04/14	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item l Customer:	ID:							
Approvals:	Process Pla	nn:	Date:	Tooling:	D:	ate:			Run	Start	~1 <i>\</i> J	R1*	
	QC:		Date:	_ SPC (Y/N):	D :	ate:				Stop	*N	R2*	
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Re Qt	ject y	Reject Number	Insp. Stamp	
120 Small Fab		Small Fab Memo		0.00				Ex				14/09/	68
Small Fab			ecessary2-Engrave P/N dow in plastic wrap	& B/N as per dwg D3543								·	
140		QC5- Inspect part comple	eteness to step on W/O	0.00				1				DAS 38	14-9-
*14 0 *		Memo		0.00				(0				9-89	

160

Identify as per dwg & Stock Location:

160 Packaging

Quality Control

Packaging

Memo

0.00

DQA:			Date:										•	TRAGE
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE				_	AEROSPACE
QA Closed:			Date:							W	ork Order up	date only		
Morle Orde						DISPOSITION			AGAIN	ST DE	PARTMENT	PROCESS		
Work Orde	er: -	***				Rework			Skid-tube Crosstu	٦٩٦	1	Water Jet	٦	Engineering
Part N	ما					Scrap			Machining Small F	<u> </u>	Pro	d. Eng. Coor.	\dashv	Quality
i aiti	•0.					Use-as-is			noforming Finishi		4	e/Packaging	┪	Other
NCR N	lo.					Suspected Unapproved			Large Fab Composi	~ —]	Supplier		
	-		-	1		· · · · · · · · · · · · · · · · · · ·			Antina		Cian 0		ļ	<u> </u>
Root	- 1			۵.	Desci	ription of work order update		Initial	Action		Sign &	Varification	١	OC Inspector
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	+	QC Inspector
Design	\dashv													
Doc/Data													-	
Equip/Tooling	-													
Handling/Pre														
Material														
Operator Offset/Setup			1											
Process		,											١	
Supplier														
Training												-	-	
Transport			ļ										١	
Unapproved														
	-						FAI	ULT CA	TEGORY					
Landi	ng (Gear				General		_			_	_		,
		Bending				Bend		Folio/F	Program		Outside Dim	ensions	_ !	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain		L	Over/Under	tolerance	_	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are '		Part Incorre	i L	_	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqualified	<u> </u>	Part Lost/Mi	ssing	-	Weld
		Cuffs				Contamination	$ldsymbol{ld}}}}}}$	Instruct	tions Incomplete/Unclear		Part Moved	L	'	Wrong Stock Pulled
		Crushing				Countersink	<u></u>	-	gned/off center	<u></u>	Positioned V	_	_	
		Heat Trea	at			Cut Too Short		Mislabe		L	Power Loss/	Surge		Other
	_	Inspection	n Strip in	Tube		Drawing		Misrea						
		Marks/Ch	natter			Drill Holes		Off-set						
		Turning S	•			Finish		-∤	Calibration					
	1	Wave/Tw	ist in Tul	oe		Fit/Function		Out of	Sequence					

Work Ord Wednesday, Jun				*120	1245*							Page 3
Item ID: Revision ID:	D3543-1			Accept	*N900	040	100)*	Setup	Start	*N:	S1*
Item Name:	Hinge Panel	Door Push-Out Window								Stop	*N?	32*
Start Date:	6/04/14	Start Qty: 4.00	*4*		Cust Item I	D:						
Required Date:	6/04/14	Req'd Qty: 4.00	*4*		Customer:							
Reference:												
Approvals:	Process P	lan:	Date:	Tooling:	Da	nte:	_		Run	Start	*NF	₹1*
	QC:		Date:	SPC (Y/N):	Da	nte:				Stop	*NF	₹2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accep Qty	ot Re Qt	-		Insp. Stamp
170		QC21- Final Inspection -	Work Order Release	0.00						1. 1	lal	- M
170 QC		Memo		0.00						14 (1112	-10

Memo

Quality Control

14/9/12 PS MF 14-9-11

DQA:			Date:										G	ART
						WORK ORDER NON-	-CC	ONFO	RMANCE / UP			_ _		EROSPACE
QA Closed:			Date:							W	ork Order up	odate only		
Work Orde	ır.					DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS		
WOIK OIU	-	•				Rework	1		Skid-tube	Crosstube		Water Jet	Fngin	eering
Part N	lo.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	_	Quality
	-			_		Use-as-is			noforming	Finishing	┥	re/Packaging	_	Other
NCR N	۱o. ِ					Suspected Unapproved			Large Fab	Composite		Supplier]	
Root	Ţ			1	Dossi	ription of work order update		nitial	Actio	on	Sign &		T	
Cause		Date	Step	Qty	Desci	or non-conformance		ief Eng			Date	Verification	OCI	Inspector
Design		Date	Step	- Qty		or non comormance	-	iici Liig	Deserr	ption				
Doc/Data														
Equip/Tooling	\dashv													
Handling/Pre														
Material														
Operator														
Offset/Setup														
Process						•								
Supplier		i												
Training													ļ	
Transport													1	
Unapproved				<u> </u>	<u></u>		<u> </u>						<u> </u>	
							FA	ULT CA	TEGORY	<u> </u>			·	
Landi	$\overline{}$	ı				General		1 ,	_	_	7		\neg _	/- '
	Ш	Bending			<u> </u>	Bend	<u> </u>	4	Program	<u> -</u>	Outside Dim		− {	e/Forced
		Centre No	ot Concei	ntric	\vdash	BOM/Route	<u> </u>	Grain		<u> </u>	Over/Under	<u> </u>	Set-up	-
	\vdash	Cracks			-	Broken/Damage/Defect		Hardwa			Part Incorre	—		ature/Cure
		Crimp/Kir	nk/Ripple	e/Wave	\vdash	Burrs	<u> </u>	4	ion Incomplete/Un	· —	Part Lost/M	-	Weld	took Dullad
	\vdash	Cuffs			 	Countains	\vdash	4	tions Incomplete/U	nciear	Part Moved	L Vrong		Stock Pulled
	$\overline{}$	Crushing			-	Countersink	-	4	gned/off center	-	Positioned V Power Loss/		Other	
	-	Heat Trea		Tuba		Cut Too Short	\vdash	Mislab Misrea		L	Trower ross/	Juige [Jourier	
i	⊢	Marks/Ch	•	rube	-	Drawing Drill Holes		Off-set						
	 	Turning S			\vdash	Finish	-	4	Calibration				.,	
		Wave/Tw			-	Fit/Function	-	-1	Sequence					
	i	1 /			1	1	1	10000						

Picklist Print

Wednesday, June 04, 2014 2:59:46 PM

Work Order ID: 120245

120245

Parent Item:

D3543-1

D3543-1

Parent Item Name: Hinge Panel Door Push-Out Window

Start Date: 6/04/14

Required Date: 6/04/14

Start Qty: 4.00

Required Qty: 4.00

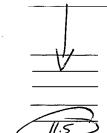
Comments:

IPP Rev:A New issue Rev B dwg 07-11-14 DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MACRLICS.125		Purchased	No			100	sf	175.7000	1.631	(F)			DAS
MACRI I	CS 125	•							**				23 1409

1/8" Polycast II Sheet

Location	Loc Oty	Loc Code
MAT019	3.7	
124559	2.5	
m125767	1.2	
therm	172	
123895	85	
m129147	87	



Page 1

9.9

DQA:			Date:										
						WORK ORDER NON-	·CC	ONFO	RMANCE / UPDATE			_	AEROSPACE
QA Closed:			Date:							W	ork Order up	odate only	
Work Orde	r:					DISPOSITION			AGAINS	T DE	PARTMENT	/PROCESS	
WOLK CIG	••••	-				Rework			Skid-tube Crosstub	e]	Water Jet	Engineering
Part N	lo.					Scrap			Machining Small Fa	_	Pro	d. Eng. Coor.	Quality
	•					Use-as-is			noforming Finishir	g	4	re/Packaging	Other
/ NCR I	lo.					Suspected Unapproved			Large Fab Composit	e		Supplier	
	•		***									•	
Root					Desci	ription of work order update	1	nitial	Action		Sign &		
Cause `		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design													
Doc/Data						:							
Equip/Tooling												:	
Handling/Pre													
Material						*							
Operator													
Offset/Setup													
Process													
Supplier													
Training						•							
Transport	_												
Unapproved	L		<u> </u>]	<u> </u>				TECODY		<u> </u>	<u> </u>	
		3					FAI	ULI CA	TEGORY				
Landi		1	Č.		_	General Bend		احمانه ره	Program	Г	Outside Dim	onsions	Pressure/Forced
		Bending Centre No			\vdash	BOM/Route	_	Grain	Togram	H	Over/Under	 	Set-up
	┢	Cracks	or concer	HIIC	-	Broken/Damage/Defect	\vdash	Hardwa	ara	\vdash	Part Incorre		Temperature/Cure
	┝	Crimp/Kir	ak/Pinnla	/\\/ava	\vdash	Burrs	┢	4	ion Incomplete/Unqualified		Part Lost/Mi	-	Weld
t.	_	Cuffs	ik) kippie	/ wave	\vdash	Contamination		1 '	tions Incomplete/Unclear	\vdash	Part Moved	-	Wrong Stock Pulled
	\vdash	Crushing				Countersink	\vdash	4 .	gned/off center	\vdash	Positioned V	∟_ Vrong	
		Heat Trea	at		-	Cut Too Short	\vdash	Mislabe	,	H	Power Loss/		Other
	\vdash	Inspectio		Tube	\vdash	Drawing	\vdash	Misrea		_	· · · · · · · · · · · · · · · · ·		
	\vdash	Marks/Ch	-		-	Drill Holes		Off-set					
	\vdash	Turning S				Finish	Г	4	Calibration				
		Wave/Tw				Fit/Function	Г	Out of	Sequence				

DART AEROSPACE LTD	Work Order:	120245
Description: Hinge Panel Door Push Out Window	Part Number:	D3543-1
Inspection Dwg: D3543 Rev: B		Page 1 of 1

				L.,,,,,,,,			ago i oi i
•	FIRS	T ARTICLE	INSPEC	TION CH	ECKLIST		
	_	First Ar	Г-		totype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Co	omments
21.95	+/-0.030	21.95	/		U=JKM-01		***************************************
10.70	+/-0.030	10.71	/				
4.00	+/-0.030	4.00		, ,, <u></u>			
0.13	+/-0.030	1/3					
						u.u	
		-					
<u>-</u>							
						•	·
			· · · · · · · · · · · · · · · · · · ·				
			DAS				
	Φ 85 🖸	1	38		1		
Measured by:	φ λ , δ	Audited by:			Prototype Ap	proval:	N/A
Date:	14/09/07	Date:	14-	9-9		Date:	N/A
Rev Date	Change		E T	1	Day	iead by	Approved
A 07.11.23	New Issue				K !/F	ised by, EC/DD 🦪	Approved
	1.1011 10000				110/1	-0,00 4	()



D3543-3 HINGE DOOR PUSH-OUT WINDOW FRAME

MOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK ALUMINUM SHEET
 - (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) IDENTIFY WITH DART P/N D3543-3 & B/N USING FINE POINT PERMANENT MARKER

-	1	.63		14.31 11.238 -		
Copyright © 2006 by				R3.75 (4 PLAC		
0 l	.50 ₂₂	2.425				
ə				·		

DRAWING NO.

2 OF 2

SCALE

06.11.24

HINGE

DOOR

PUSH-OUT WINDOW